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RBE350A94-3700-A-1A
Job Sheet 194557



Part No: RBE350A94-3700-A-1A

Job Qty: 12 pcs **33**

Part Name: Long Brace Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	12 pcs	6/14/19		0.00	1.20	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	12 pcs	6/14/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	12 pcs	6/14/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		

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40
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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	12 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - Small Fab-3 (Small Fab) -Assemble as per DWG. Sheet 2 -Loctite 262 B *1489704* Exp: *01/20* -See
 Descriptions: note 1 *5157322*

120 - QC5 (QC5- Inspect part completeness to step on W/O)

130 - Packaging3-1 (Identify as per dwg & Stock Location: _____)

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	66 Ea (2 ea)	110-Small Fab - 1	61X 5150648 5X 5184132
92905A225	Extended Point Set Screw, Dog Point	12 Ea (1 ea)	110-Small Fab - 1	5180928
CL-2-C	Lanyard Wire	15.6000 ft (1.3 ea)	110-Small Fab - 1	5119833
NAS1756-12	Remove Before Flight	12 Ea (1 ea)	110-Small Fab - 1	5183173
RBE350A94-3700-A-01	Tube	12 pcs (1 ea)	110-Small Fab - 1	1X 5136777 8X 5161333 24X 5178035
RBE350A94-3700-A-03	Top	12 pcs (1 ea)	110-Small Fab - 1	3X 5047551 8X 5104869 21X 5181364
RBE350A94-3700-A-05	Foot	12 pcs (1 ea)	110-Small Fab - 1	24X 5172057 9X 5117439

Job Allocations

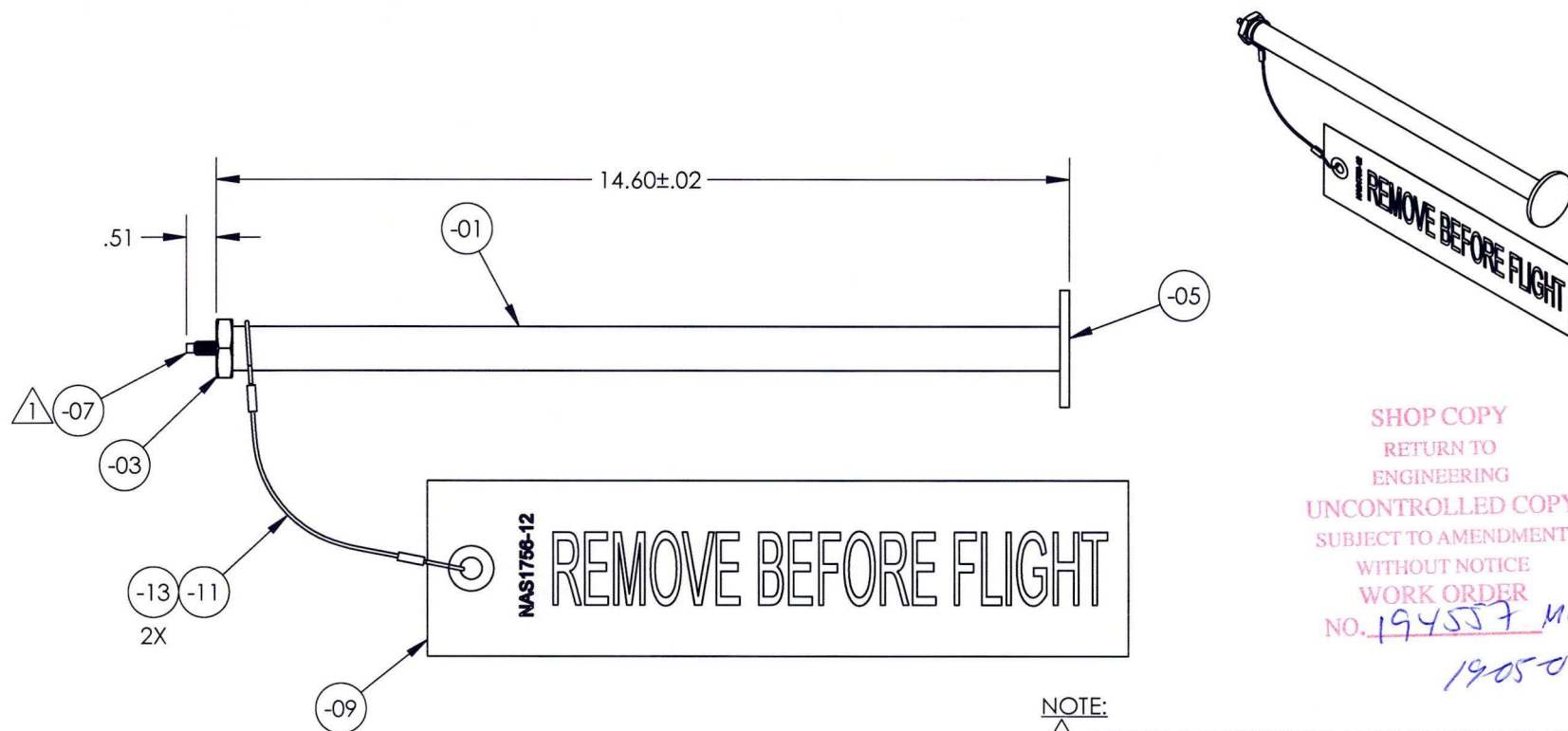
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	3896T31	24	487	0
	92905A225	12	59	0
	CL-2-C	16	222	0
	NAS1756-12	12	202	0
	RBE350A94-3700-A-01	12	41	0
	RBE350A94-3700-A-03	12	11	0
	RBE350A94-3700-A-05	12	42	0

Part Specifications
Specifications could not be found.

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
7	16-0282	-1A ADDED TO BOM QTY: 3. ADDED DRAWING.			1/3/2017	DPD JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194557 MJS
190506

NOTE:

- 1 APPLY LOCTITE 262 TO MATING THREADS OF
-03 CAP & -07 EXTENDED POINT SET SCREW,
DOG POINT.

(1A)
LONG BRACE ASSEMBLY

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL LONG BRACE	
DWG NO. RBE350A94-3700-A-1A	REV 7
MAT'L _____ HEAT _____ TREAT _____ FINISH _____ SPEC _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: MACKOVJAK	EUROCOPTER AS350/355
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:3	DATE 8/21/2012 SHEET 2 OF 5

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					